

Work Order ID 100044

100044

Page 1

April-17-13 8:09:50 AM

Item ID: D4423-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Splash Guard Extension

Start Date: 4/17/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *130417* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4423	A
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100	FLOW WATER JET	0.00
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100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4423

Dwg Rev: *A*

Prog rev: *A*

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110

QC

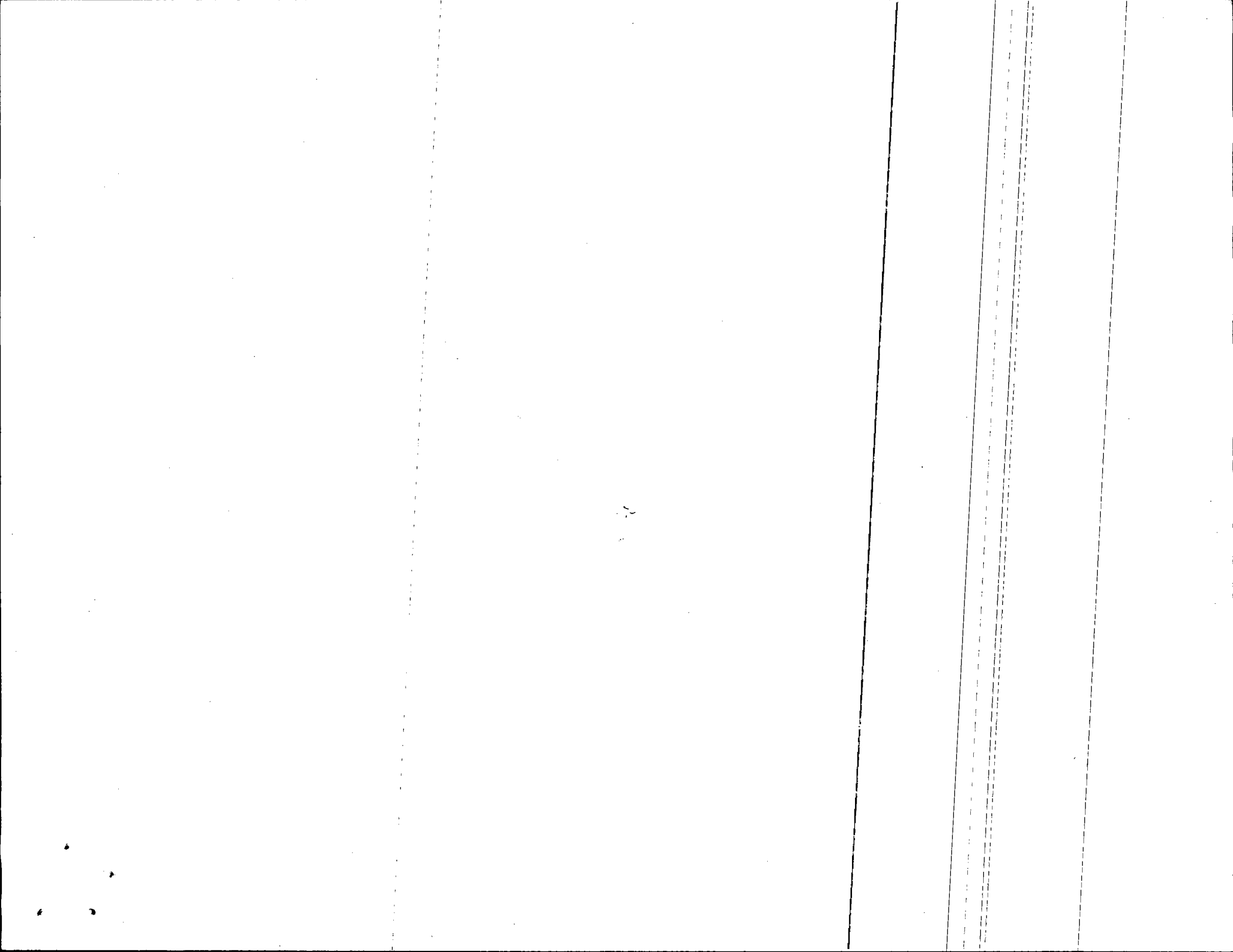
Memo

0.00

Quality Control

6 0 Jm13-4-18

6 6 Jm13-4-18



Work Order ID 100044

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Page 2

April-17-13 8:09:50 AM

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

21
13418

6

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3065

6

SB
13/04/22

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
16
9-83
13/04/22

+6

0

Work Order ID 100044

100044

Page 3

April 17 13 8:09:50 AM

Item ID: D4423-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Splash Guard Extension

Stop *NS2*

Start Date: 4/17/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

6 RB 13-4-23

165

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

165

Powdercoat

Memo

0.00

Powder Coating

Start Time: 2:20
Temp: 32.5°F
Finish Time: 2:50

6 x p m 13/04/24

M122966

170

QC3- Inspect Part Finish

0.00

170

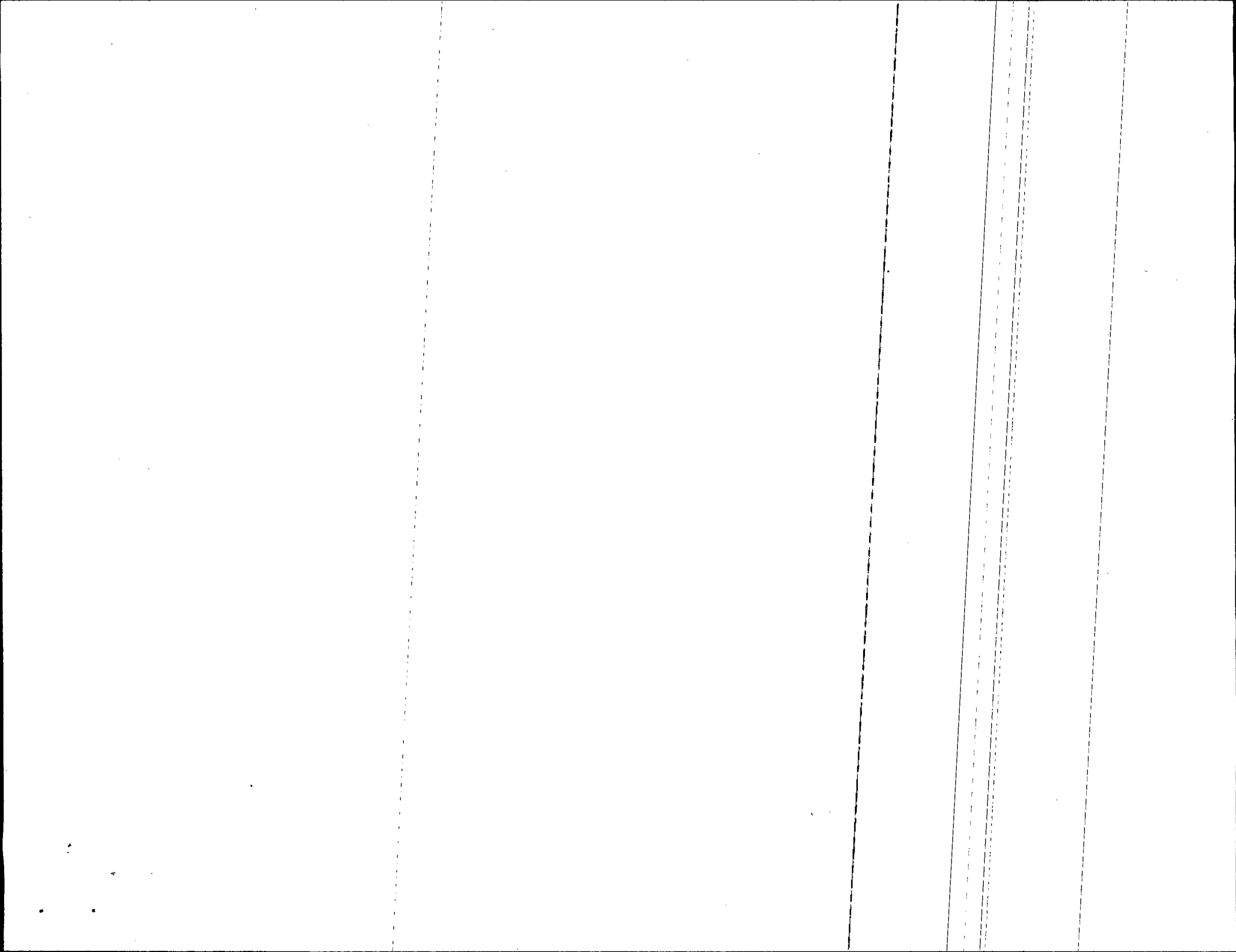
QC

Memo

0.00

Quality Control

6 p 13-4-24



Work Order ID 100044

100044

Page 4

April-17-13 8:09:50 AM

Item ID: D4423-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Splash Guard Extension

Start Date: 4/17/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

5/10/9

0.00

Packaging

13/5/12 (6)

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

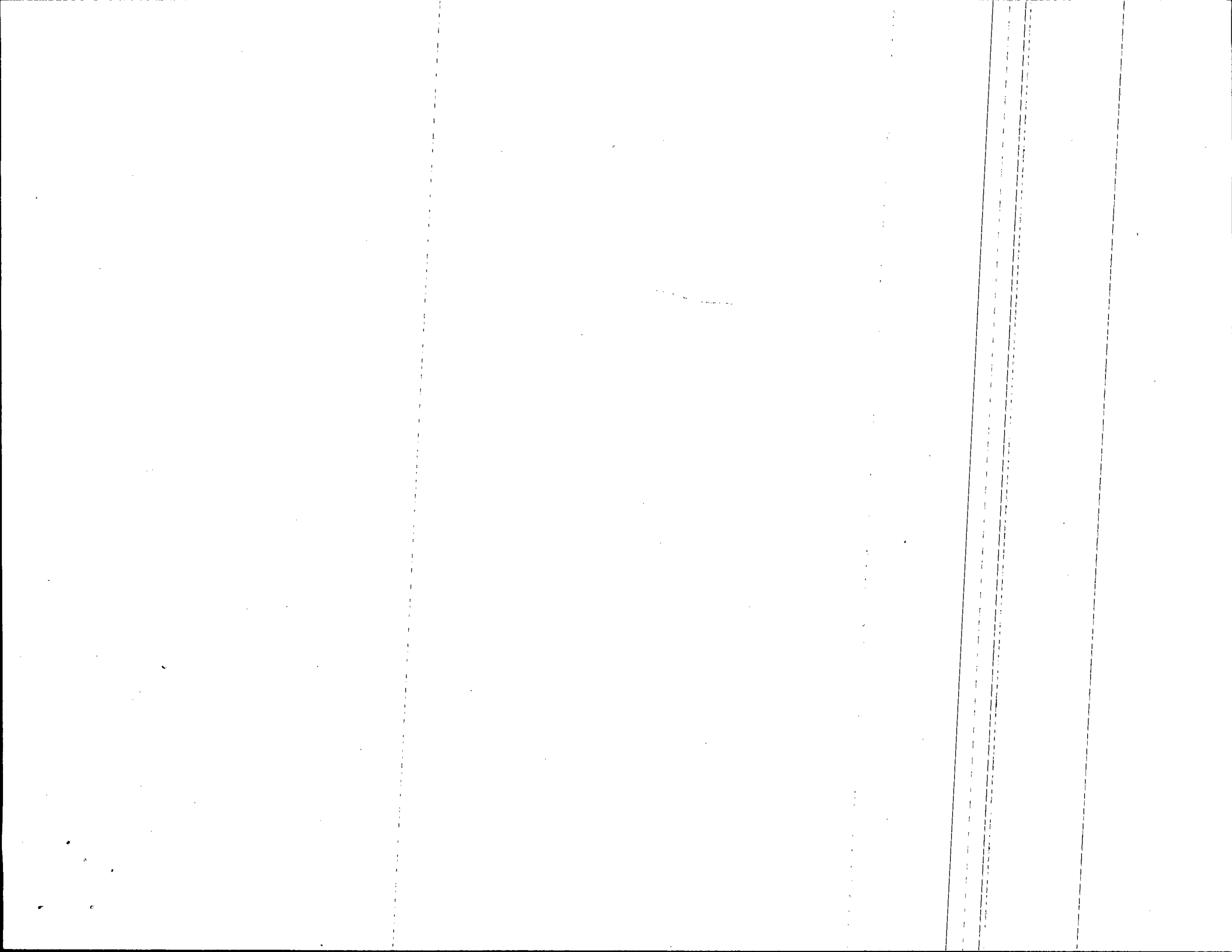
Memo

0.00

Quality Control

13/5/16 28

MF
13-4-29



Picklist Print

April 17, 2013 8:09:54 AM

Work Order ID: 100044

Parent Item: D4423-1

Parent Item Name: Splash Guard Extension

100044

D4423-1

Start Date: 4/17/13

Required Date: 5/03/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased			No		sf	1,025.070		2,830.105			
									**	3.0			JM13-4-18
M6061T6S 032													
6061-T6 Sheet 0.032"													

Location

MAT021

Loc Qty

1025.07

Loc Code

121099

171.94

122256

46.78

122737

44.8

123097

71.9

123135

37.7

123137

60.05

123293

58.5

123483

260.6

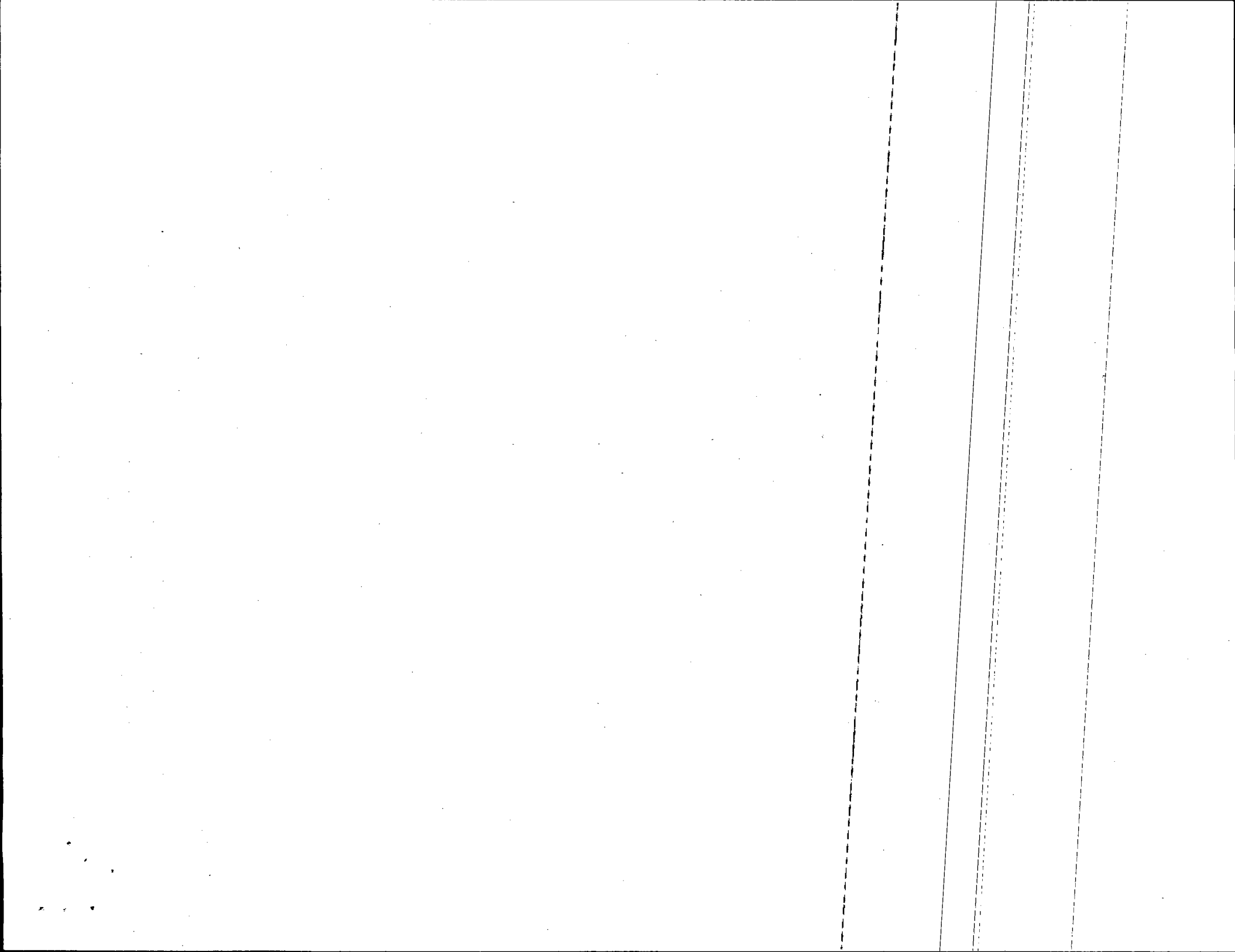
123701

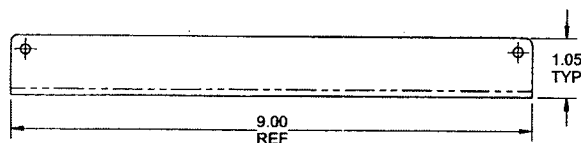
52.95

124629

219.85

123701









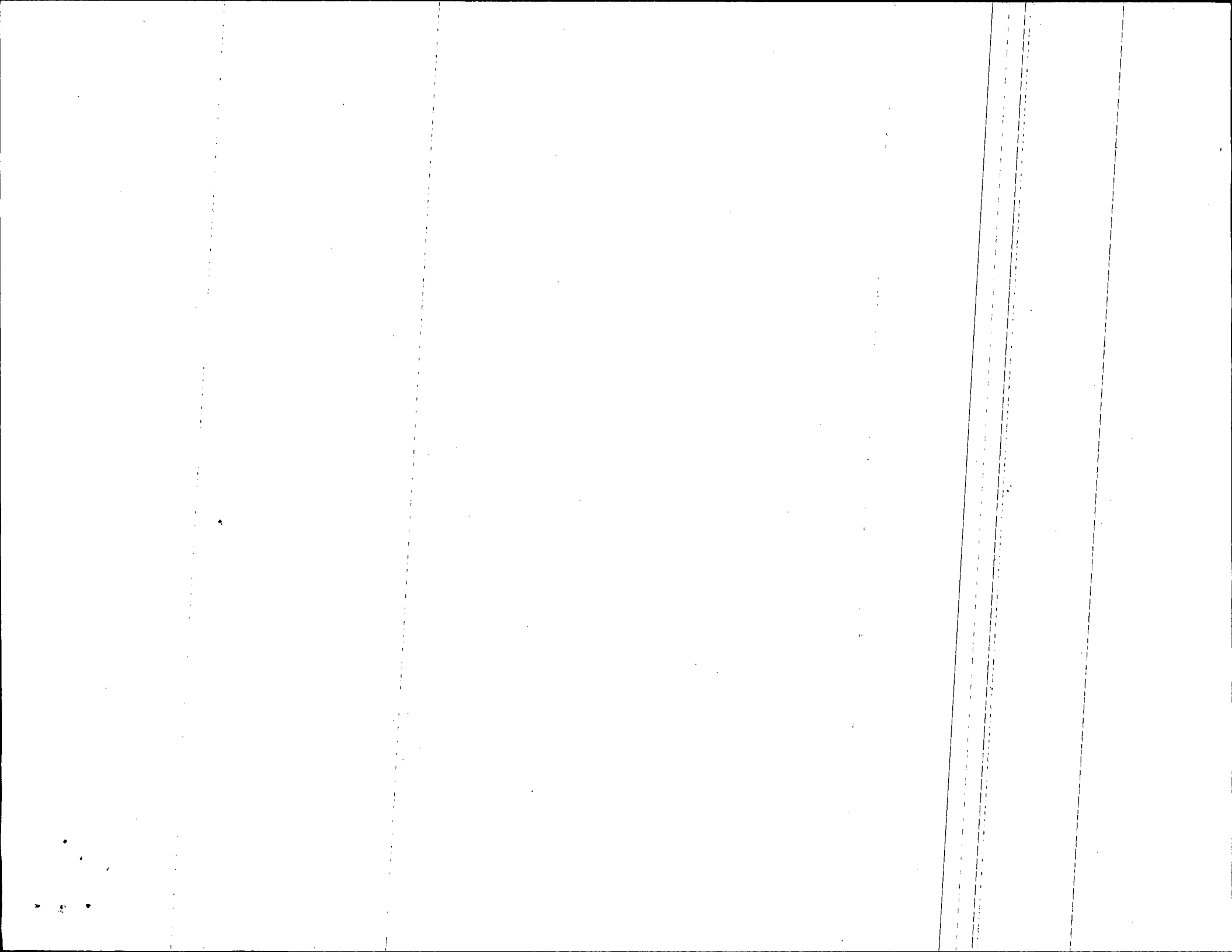
D4423-1 SPLASH GUARD EXTENSION

COPY
 TO
 FROM
 FULL COPY
 TO
 WITH
 ORDER
 100044 MCL
 13-04-13

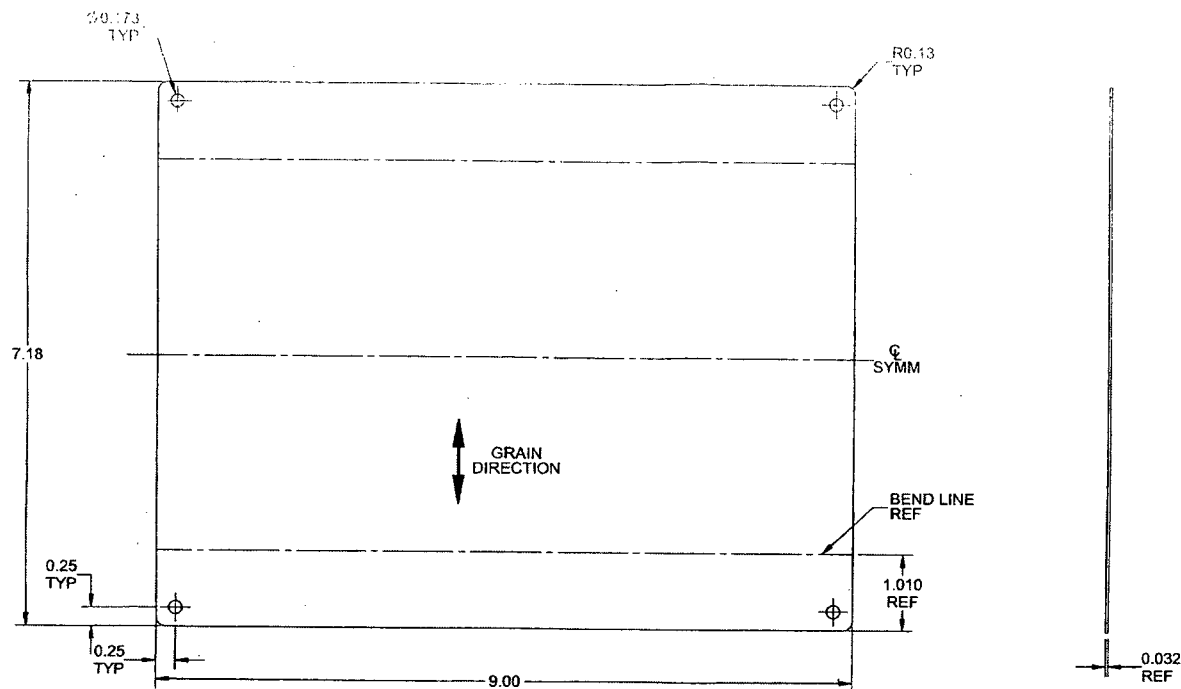
RELEASED
2011-07-06

- NOTES:**
1) MATERIAL: MAKE FROM D4423-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4423-1" AND B/N PER QSI 044 6.1
7) WEIGHT: 0.20 Lbs.

A	NEW ISSUE		MB	11.06.22
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4423 TITLE SPLASH GUARD EXTENSION	REV. A	
DRAWN			SHEET 1 OF	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED				
DE APPR.				
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100044



D4423-1F SPLASH GUARD EXTENSION FLAT PATTERN

RELEASED
2011-07-06

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4423	REV. A
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE SPLASH GUARD EXTENSION	SCALE NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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